

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER :									

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Work Order ID 148217

Monday, June 27, 2016 11:42:50 AM

148217

Page 3

Item ID: D4776-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Spacer
Start Date: 6/21/2016 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 6/27/2016 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.33							
Quality Control									

DAS
21
9-89
JUL 26 2016

DAS
21
9-89
JUL 26 2016

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Picklist Print

Monday, June 27, 2016 11:42:50 AM

Page 1

Work Order ID: 148217

148217

Parent Item: D4776-5

D4776-5

Parent Item Name: Spacer

Start Date: 6/21/2016

Required Date: 6/27/2016

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A NEW ISSUE 13-08-30 JLM VERIFIED BY:DD IPP
REV:B 13.09.26 AS PER REV.B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.500		Purchased	No				f	26.3670		0.421053			

M6061T6R0 500

6061-T6 Round Bar .500"

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT012	26.367	
M129845	0.5	
M132876	1.867	
<u>M134776</u>	24	

0.711
DAS
45 2016-7-23
9-89

DQA: _____ Date: _____

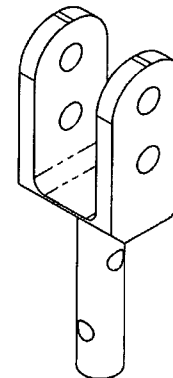
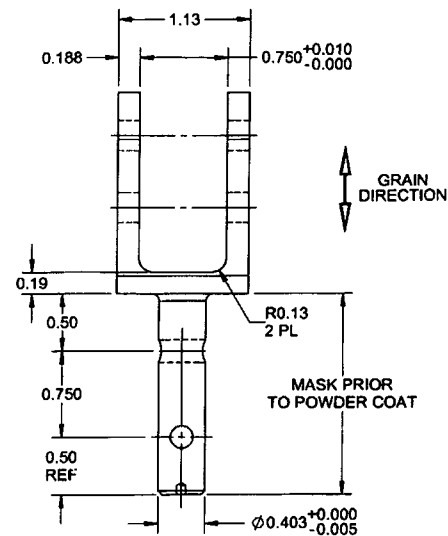
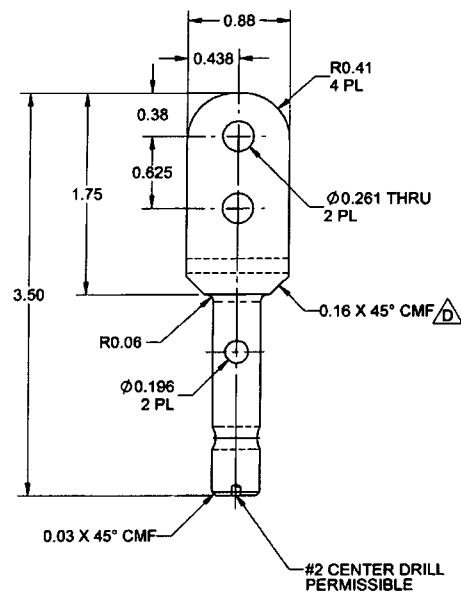


WORK ORDER NON-CONFORMANCE / UPDATE

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DAS
13
9-89

JUN 27 2016

W10: 148217

RELEASED
2014-07-30

D4776-1 BASKET STRUT CLEVIS

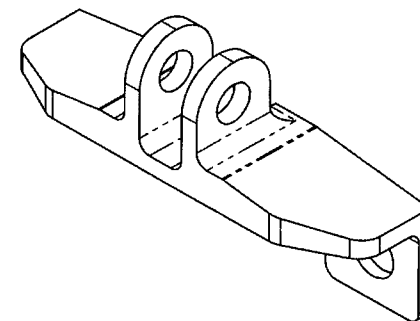
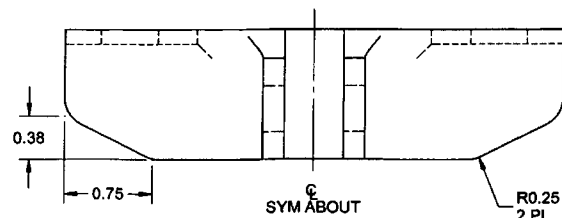
NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8
(OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

D	SHT 1, C8 CHAMFER ADDED. SEE PAR 14-353. SHT 2 ZONE B2 1.813 DIM ADDED FOR CLARITY. ZONE B3 0.53 DIM CORRECTED TO 0.55 DUE TO DESIGN ERROR SEE PAR 14-328.	AJS	14.07.14
C	SHT 2, C7, 1.13 DIM WAS 0.88, C8 0.688 WAS 0.438, ADDED TOP VIEW WITH CHAMFERS. REASON: INTERFERENCE WITH OEM SADDLES.	AJS	13.10.31
B	MULTIPLE DIMENSIONS UPDATED ON -1 FOR INSTALLATION OF 1/4" FASTENERS. INDEX OF HOLES ON THE STEM OF -1 ROTATED 90°. FINISH ADDED TO -1. TOLERANCE ON CLEVIS FOR -1 & -3 TIGHTENED. ADDED -5. REASON: EASE OF INSTALLATION. C3-2 DEPTH DIM ADDED.	AJS	13.08.14
A	NEW ISSUE	AJS	13.08.08
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESSBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4776	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET STRUT MACHINED PARTS	NT
DATE	14.07.14	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

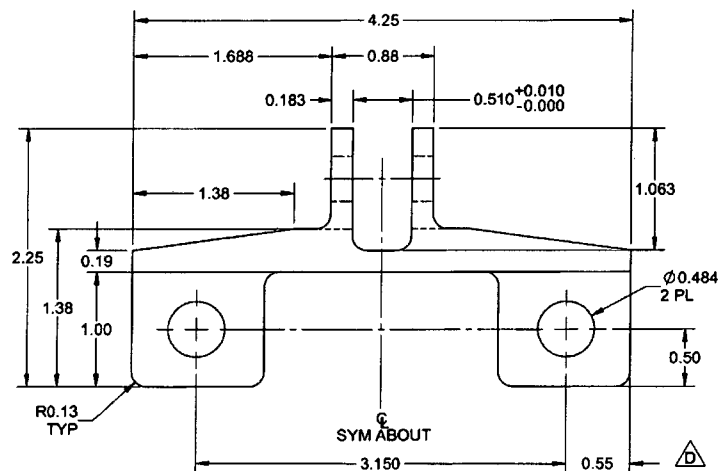
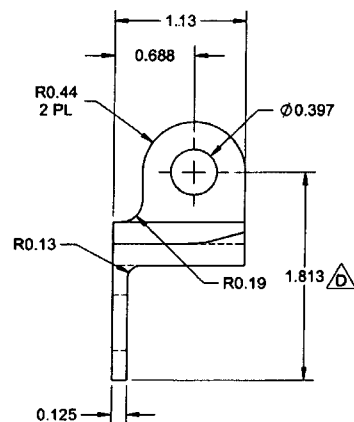
8 7 6 5 4 3 2 1

D



D

C



GRAIN
DIRECTION

B

RELEASED
2014-07-30
wp

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8
(OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.1
- 7) WEIGHT: 0.18 lbs

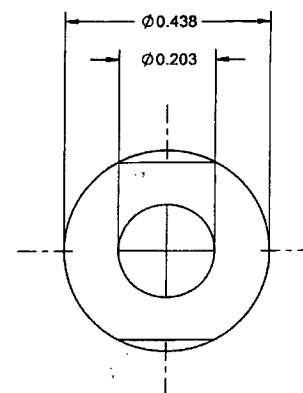
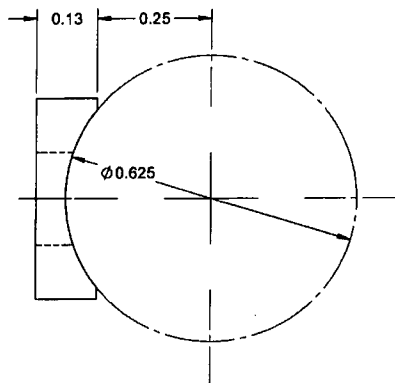
D4776-3 SKIDTUBE CLEVIS

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4776	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET STRUT MACHINED PARTS	NTS
DATE	14.07.14	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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D4776-5 SPACER



NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4776-5" AND B/N PER QSI 044 METHOD 6.7
- 7) WEIGHT: LESS THAN 0.01 lbs

RELEASED
2014-07-30

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	AJS	D4776	SHEET 3 OF 3
APPROVED	AJS	TITLE	SCALE
DE APPR.	AJS	BASKET STRUT MACHINED PARTS	NTS
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